

Date: Tuesday, 3/11/2008 11:25:14 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PIN ASSEMBLY
Job Number : 37784	
Estimate Number : 11339	
P.O. Number :	Part Number : D3332041
This Issue : 3/11/2008 S.O. No. :	Drawing Number : D3332 REV. A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A1
Previous Run : 35441	Material :
Written By :	Due Date : 3/31/2008 Qty: 10 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est: A 05.01.13 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1018R0500	1018-1025 Steel Bar
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Comment: Qty.: 0.3281 f(s)/Unit Total : 3.2813 f(s)
1018-1025 Steel Bar
Material: AISI 1018-1025 Ø0.500" Round Bar
(M1018-R0.500)
Identify for D3332-1
Batch: 1106996

10

mmf 08/04/14

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL
Machine D3332-3 as per Folio FA493 and Dwg D3332

mmf 08/04/14

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf 08/04/14

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

mmf 08-04-14

10

5.0	M1018R0313	1018-1025 Steel Bar
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Comment: Qty.: 0.4594 f(s)/Unit Total : 4.5938 f(s)
1018-1025 Steel Bar
Material: AISI 1018-1025 Ø0.313" Round Bar
(M1018-R0.313)
Identify as D3332-5
Batch: B17270

*

mmf 08/05/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 11:25:14 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIN ASSEMBLY

Job Number: 37784

Part Number: D3332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Fabricate D3332-5 as per Dwg D3332

SD 08/05/23

7.0

D33321

Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
Handle Assembly
Pick:
Qty Part Number Description Batch
1 D3332-1 Handle *B37083* ✓
A/R N/A Steel Rod *M105138* ✓
Identify as D3332-041

SD 08/05/23

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Assemble and Weld using D3332-041T1 as per Dwg D3332

SD 08/05/23

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD 08/05/23

30 min
27/05/2008
S.280 13.06
#1 318.5 F
#2 1337784 F
#3 D3332041 F
#4

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3
Cover thread only for D3332-5 prior to painting

m. 08/05/23

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FD 08/05/27

(10)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *490*

8/5/27

(X20)
50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: PIN ASSEMBLY

Job Number: 37784

Part Number: D3332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/29 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

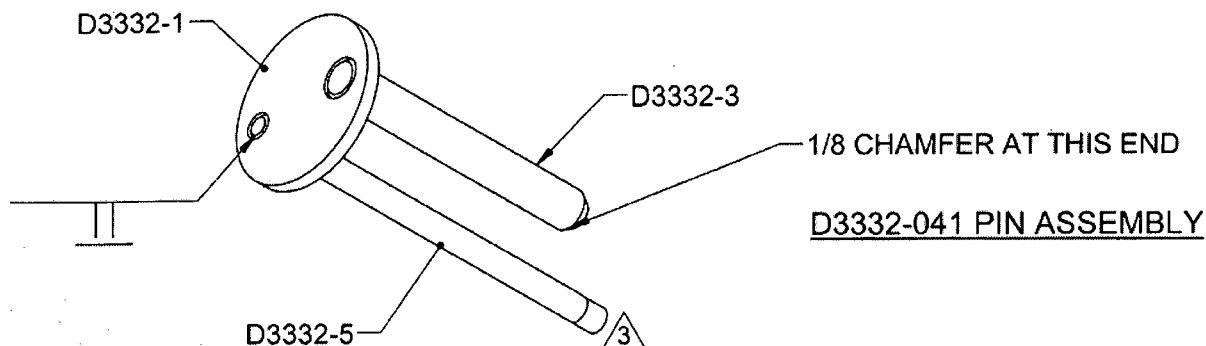
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

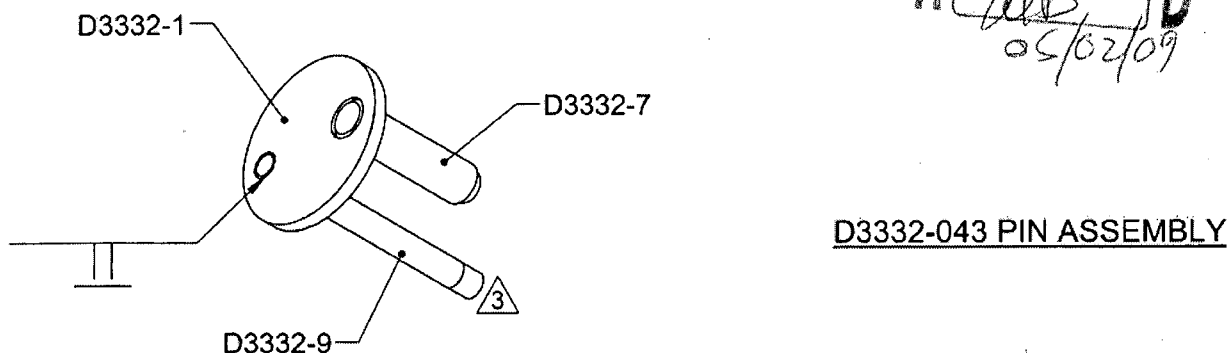
NOTE: Date & initial all entries



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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:2
A	04.12.14	NEW ISSUE	
A1	<i>[Signature]</i> 05.07.04	0.080 WAS 0.050; ADD TOLERANCE ± 0.000 -0.005	



RELEASED
[Signature]
05/02/09



NOTES:

- 1) POSITION PARTS USING D3332-041T1
- 2) WELD PER DART QSI 004
- 3) MASK THREADS PRIOR PAINTING
- 4) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3
(COVER THREAD ONLY FOR D3332-5/-9 PRIOR PAINTING)
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.10

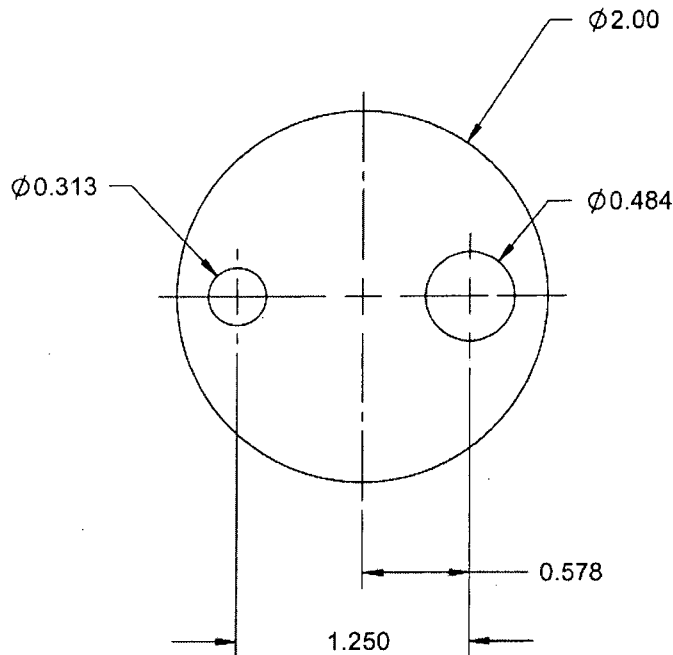
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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



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[Signature]
05/02/09

D3332-1 HANDLE

NOTES:

- 1) MATERIAL: 1018-25 ROUND BAR STEEL PER MIL-S-7097
(REF. DART SPEC. M1018-R2.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

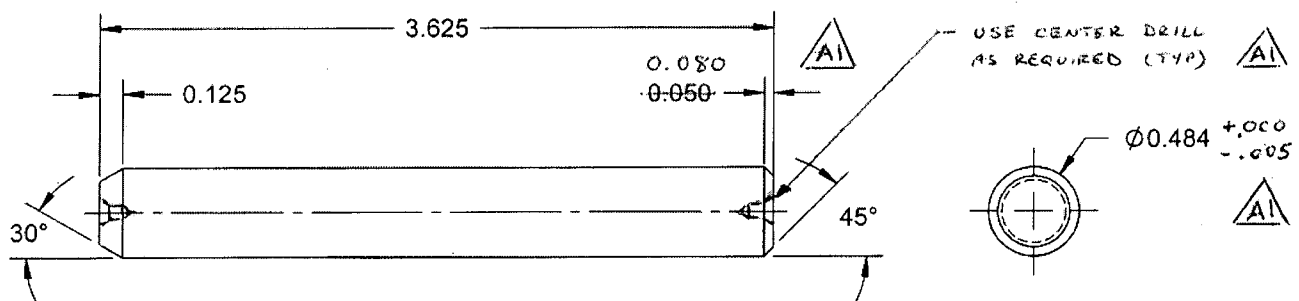
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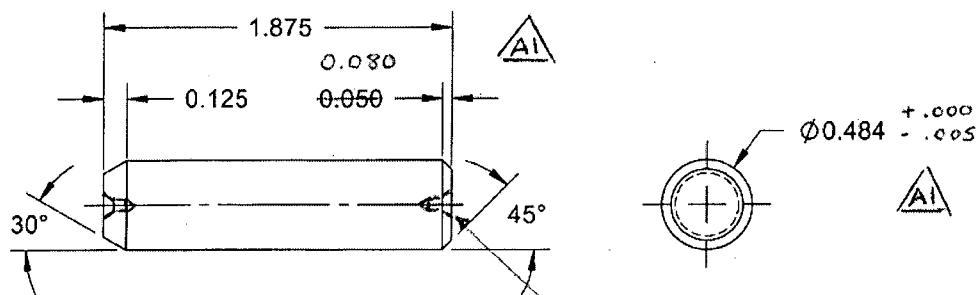


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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



3332-3 PIN

RELEASED
[Signature]
05/02/09



3332-7 PIN

USE CENTER DRILL
AS REQUIRED (TYP)

NOTES:

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097 (REF. DART SPEC. M1018R0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

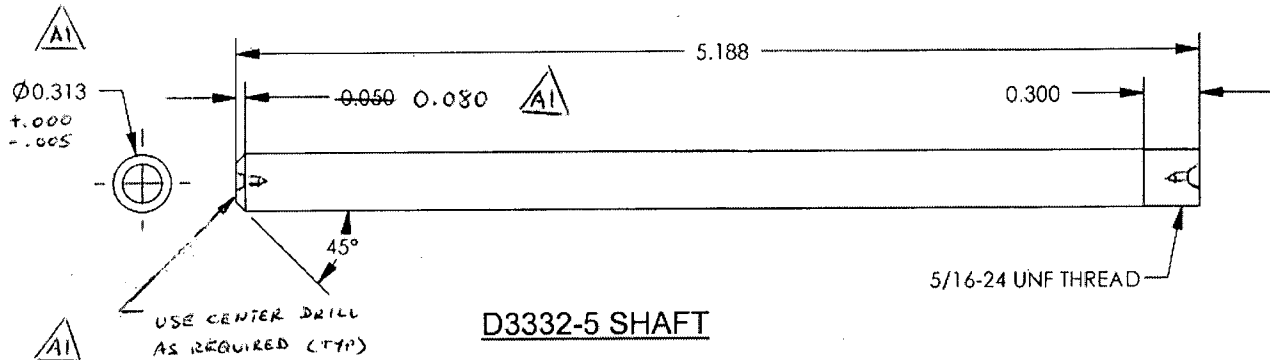
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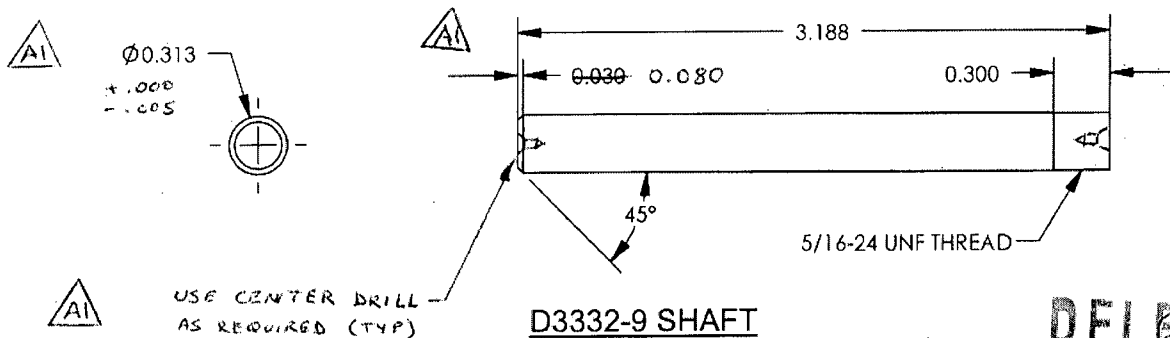
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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



D3332-5 SHAFT



D3332-9 SHAFT

NOTES:

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097 (REF. DART SPEC. M1018-R0.313)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES

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05/02/09

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